Slip June 19

Work Order ID 120621

June-09-14 8:44:04 AM

120621

D3180-042

B120621

8

Item ID: D3180-042 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Strut Assembly, RH **Stop** *NS2*

Start Date: 6/09/14 **Start Qty:** ~~10.00~~ *10*

Required Date: 6/16/14 **Req'd Qty:** 10.00 *10*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3180	C								
100		0.00							
100	NC BRAKE				DAS 30 9-89	8			14-06-16
Brake NC	**Memo**	0.00							
Brake NC	1-Punch Tubing to length as per Dwg D3180-2 using DT8313, DWG D2638								
110		0.00							FJ
110	Small Fab					8			14-06-16
Small Fab	**Memo**	0.00							
Small Fab	1-Drill holes as per Dwg D3180								
	2-Bend strut as per Dwg D3180								
	3-Deburr edges								

Item ID: D3180-042 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Strut Assembly, RH
Start Date: 6/09/14 **Start Qty:** 10.00 *10*
Required Date: 6/16/14 **Req'd Qty:** 10.00 *10*
Reference: **Cust Item ID:** **Customer:**

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				8			
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum **Memo** START TIME: 12:00 OVEN TEMPERATURE: 400° FINISH TIME: 12:30	0.00 0.00				8		14-6-17	DAS 34 9-89
140 *140* QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				8			

DAS 27 9-89 14/6/17

Item ID: D3180-042 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Strut Assembly, RH
Start Date: 6/09/14 **Start Qty:** 10.00 *10*
Required Date: 6/16/14 **Req'd Qty:** 10.00 *10*
Reference:
Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00				8		FF 14-06-17	
150	Small Fab								
Small Fab	**Memo**	0.00							
Small Fab	1-Assemble as per Dwg D3180								
160	QC5- Inspect part completeness to step on W/O	0.00	DAS 27 9-89 14/6/18			8			
160									
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: ST	0.00				8 X	DAS 28 9-89		JUN 18 2014
170									
Packaging	**Memo**	0.00							
Packaging									

Item ID: D3180-042 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Strut Assembly, RH
Start Date: 6/09/14 **Start Qty:** 10.00 *10* **Cust Item ID:**
Required Date: 6/16/14 **Req'd Qty:** 10.00 *10* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180 QC Quality Control	Memo	0.00				MLJ	14-06-18		

MF 14-6-18

Picklist Print

June-09-14 8:44:02 AM

<3

Work Order ID: *120621*

120621

Parent Item: D3180-042

D3180-042

Parent Item Name: Strut Assembly, RH

Start Date: 6/09/14 **Required Date:** 6/16/14

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP REV:A 14.04.11 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6		Manufactured	No				Each	51.0000		10			
D2690-6									**		FF	14-06-17	
Lanyard													
				Location				**Loc Qty**	**Loc Code**				
				ST014				51					
					102246			4					
					115851			16		8			
					117190			31					
M304TR0.750W.065		Purchased	No				f	50.0000		38			
M304TR0.750W.065									**		DAS 30 9-89	14/04/14	
304 RD Tube .750 x .065W													
				Location				**Loc Qty**	**Loc Code**				
				MAT017				50					
					114002			10					
					118390			40		~~40~~ 36			
D2022-101		Manufactured	No				Each	295.0000		20			
D2022-101									**		FF	14-06-17	
Spacer													
				Location				**Loc Qty**	**Loc Code**				
				ST003				35					
					113339			35		10			
				ST004				260					
					103016			50					
					106235			24					
					107903			80					
					117874			100					
					92861			4					
					98450			2					

Work Order ID: 120621
120621
Parent Item: D3180-042
D3180-042
Parent Item Name: Strut Assembly, RH

Start Date: 6/09/14 **Required Date:** 6/16/14
Start Qty: 10.00 **Required Qty:** 10.00

A1449	Purchased	No	Each	1,169.000	**	10

A1449
Grommet

FF 14-06-17

Location	Loc Qty	Loc Code	
ST278	1169		
1487	1169		8

MS17984-C310	Purchased	No	Each	0.0000	**	10

MS17984-C310
Quick Release Pin

~~128300~~ 129444

8 FF 14-06-17

MS21042L3	Purchased	No	Each	6,151.000	**	10

MS21042L3
Nut

FF 14-06-17

Location	Loc Qty	Loc Code	
ST314	109		
108816	9		
M127410	13		
M127831	39		
M128401	48		
ST506	955		
123900	955		
ST509	5087		
M127831	2		
~~M128754~~	5085		8

Work Order ID: 120621
120621
Parent Item: D3180-042
D3180-042
Parent Item Name: Strut Assembly, RH

Start Date: 6/09/14 **Required Date:** 6/16/14
Start Qty: 10.00 **Required Qty:** 10.00

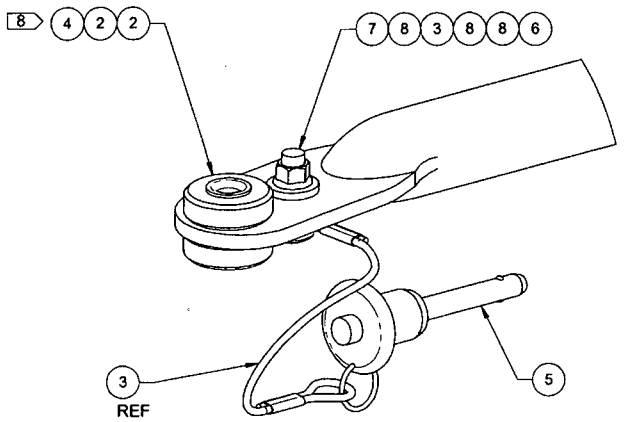
MS27039-1-10	Purchased	No		Each	742.0000	10
MS27039-1-10					**	FF 14-06-17
SCREW						

Location		Loc Qty	Loc Code	
ST305		103		
	m126474	1		
	m128401	102		8
ST506		600		
	m128635	600		
st507		39		
	m127993	39		

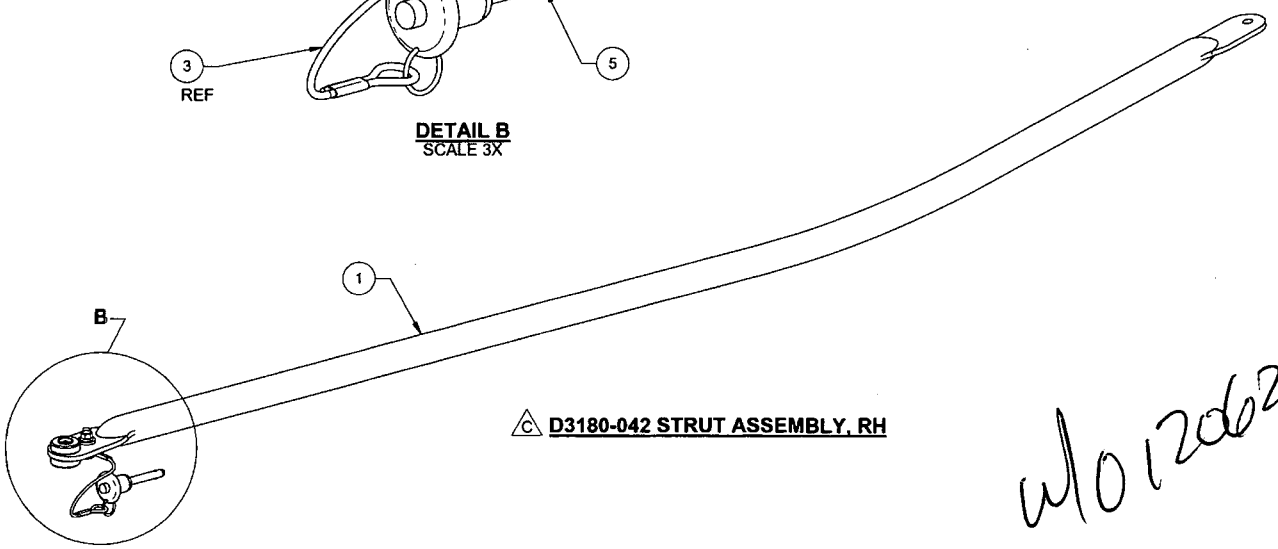
NAS1149D0363J	Purchased	No		Each	3,576.000	30
NAS1149D0363J					**	FF 14-06-17
Washer						

Location		Loc Qty	Loc Code	
GA		23		
	124392	23		
ST510a		3553		
	109061	9		
	m126319	6		
	m128429	3538		24

ITEM	QTY -042	P/N	DESCRIPTION
	X	D3180-042	STRUT ASSEMBLY, RH
1	1	D3180-2	STRUT
2	2	D2022-101	SPACER
3	1	D2690-6	LANYARD
4	1	A1449	GROMMET
5	1	MS17984-C310	PIN, QUICK RELEASE
6	1	MS21042L3	NUT, SELF-LOCKING
7	1	MS27039-1-10	SCREW, PAN-HEAD
8	3	NAS1149D0363J	WASHER



DETAIL B
SCALE 3X



C **D3180-042 STRUT ASSEMBLY, RH**

W012021

RELEASED
2014 -10- 04
MP

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3180-042" AND BATCH NUMBER PER QSI 044 6.1
7) WEIGHT: 1.86 lbs
8) SWAGE D2022-101 SPACERS ONTO D3180-2 STRUT USING A1449 GROMMET

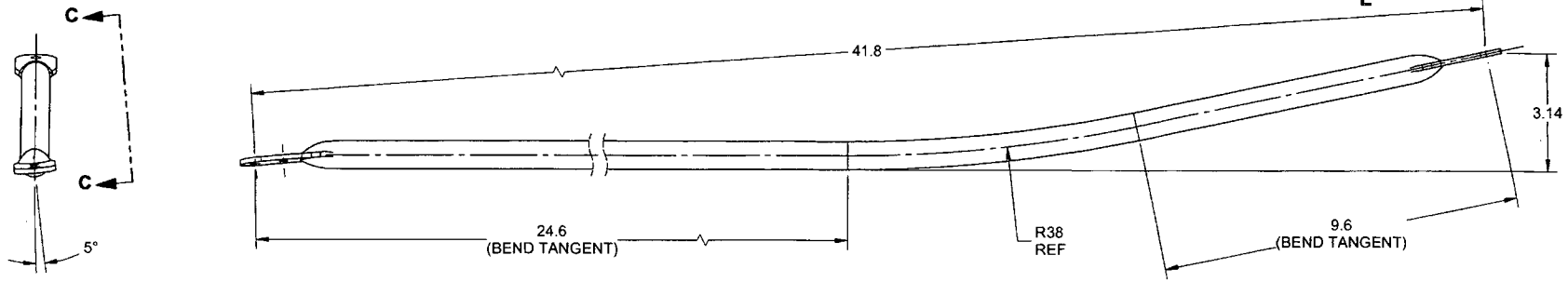
APPROVED

DESIGN	DS
DRAWN	MB
CHECKED	AP
MFG. APPR.	JLM
APPROVED	MP
DE APPR.	DS
DATE	14.03.24

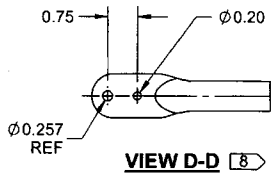
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3180 REV. C
SHEET 2 OF 4
TITLE STRUT ASSEMBLY SCALE NTS

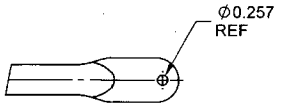
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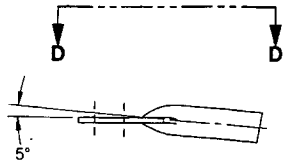
D3180-1 STRUT



VIEW D-D 8



VIEW E-E 8



VIEW C-C

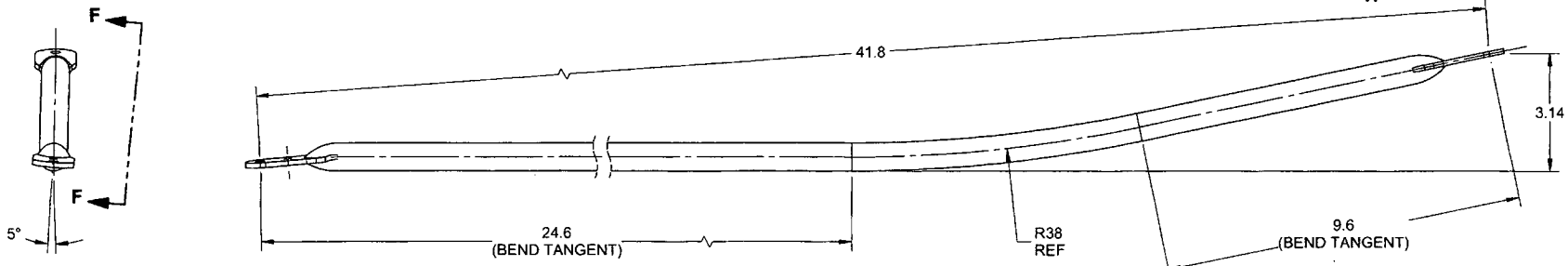
RELEASED
2014 -10- 04

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
Ø0.75 X 0.065 WALL, PER ASTM A213 OR ASME SA213 OR ASTM A269
REF. DART SPEC. M304TR0.750W.065
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.82 lbs
8) PUNCH: PER SPEC. CONTROL DWG D2638

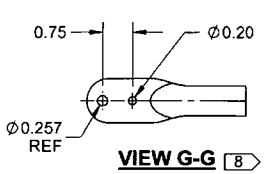
APPROVED

DESIGN	DS	**DART AEROSPACE LTD**
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO. D3180 — REV. C
MFG. APPR.	JLM	SHEET 3 OF 4
APPROVED	MP	TITLE: STRUT ASSEMBLY — SCALE: NTS
DE APPR.	DS	
DATE	14.03.24	

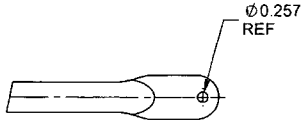
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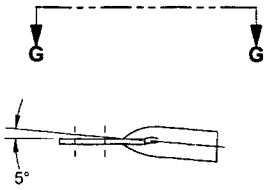
C **D3180-2 STRUT**



VIEW G-G 8



VIEW H-H 8



SECTION F-F

RELEASED
2014-10-04

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
Ø0.75 X 0.065 WALL, PER ASTM A213 OR ASME SA213 OR ASTM A269
REF. DART SPEC. M304TR0.750W.065
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.82 lbs
8) PUNCH: PER SPEC. CONTROL DWG D2638

APPROVED

DESIGN	DS	DART AEROSPACE LTD
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO. D3180 REV. C
MFG. APPR.	JLM	SHEET 4 OF 4
APPROVED	MP	TITLE STRUT ASSEMBLY SCALE NTS
DE APPR.	DS	
DATE	14.03.24	

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DART AEROSPACE LTD

Description: Stud Assembly RH Work Order: 120621

Inspection Drawing: D3180 Rev: C Part Number: D3180-042

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
42.813	±.030	42.813	✓		T	SB-5
5°	±1/2	5°	✓		SB AB-01	SB AB-01
.75					SB	SB-4
Ø0.20					SB	SB-4
Ø.257					SB	SB-4

Measured by: DAS 30 9-89	Checked By: DAS 36 9-89	QC inspector: DAS 27 9-89	Engineering Approval (*if necessary*)
Date 14/06/11	Date 14/06/11	Date 14/6/17	Date